

Work Order ID 81431

Wednesday, March 14, 2012 10:56:27 AM

(*81431*)

Page 1

Item ID: D4034-043 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fwd Upper Rib Assembly
 Start Date: 3/14/2012 Start Qty: 3.00 *3*
 Required Date: 3/30/2012 Req'd Qty: 3.00 *3*
 Reference: Cust Item ID:
 Customer:

Approvals: Process Plan: umf Date: 12-03-13 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4034	B

100 Weld per dwg A/R S.S. rod Batch: 1114509 0.00

100

Large Fab

Large Fab

Memo

0.00

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib as per dwg

② mc 12-05-16

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

2X φ PL 12-05-16

120

QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

8/2/16

② _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, March 14, 2012 10:56:27 AM

81431

Page 2

Accept

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 3/14/2012 **Start Qty:** 3.00 ***3***

Cust Item ID:

Required Date: 3/30/2012 **Req'd Qty:** 3.00 ***2***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID**Tool #**

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0,00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

_____ *SL* 12.05.16

12/5/17 *[Signature]*

MF
12-05-16

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NOTE: Date & initial all entries

Picklist Print

Wednesday, March 14, 2012 10:56:27 AM

Page 1

Work Order ID: 81431

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly

Start Date: 3/14/2012

Required Date: 3/30/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
verified by:EC IPP Rev:B as per dwg revA 10.03.15
IPP Rev:C 11.01.19 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1 Rib		Manufactured	No			100	Each	5.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA006		5							
				78262		5							
D4034-5 Rib		Manufactured	No			100	Each	8.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				75656		2							
				WA005		5							
				67339		1							
				79418		4							
				WA006		1							
				70343		1							
D2327-3 Spacer Bushing		Manufactured	No			100	Each	24.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		22							
				79333		22							
				WA005		2							
				75564		1							
				77229		1							
D4021-7 Hoop		Manufactured	No			100	Each	7.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		7							
				79877		7							

B81145³→2x MC

B82983³→2x MC

B82706³→2x MC

B82704³→2x MC

Dart Aerospace Ltd

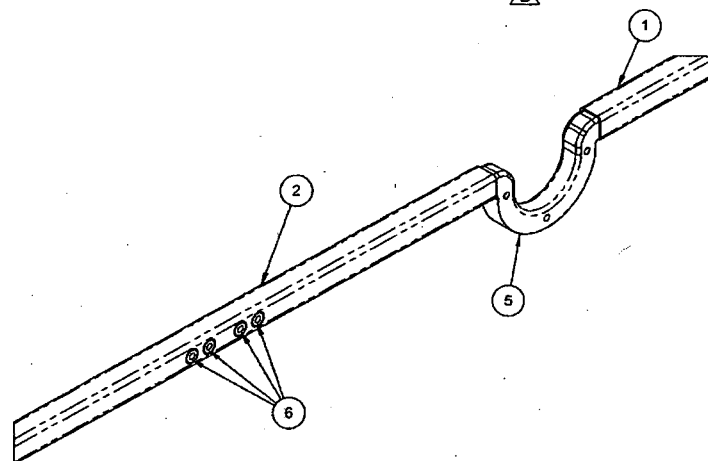
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

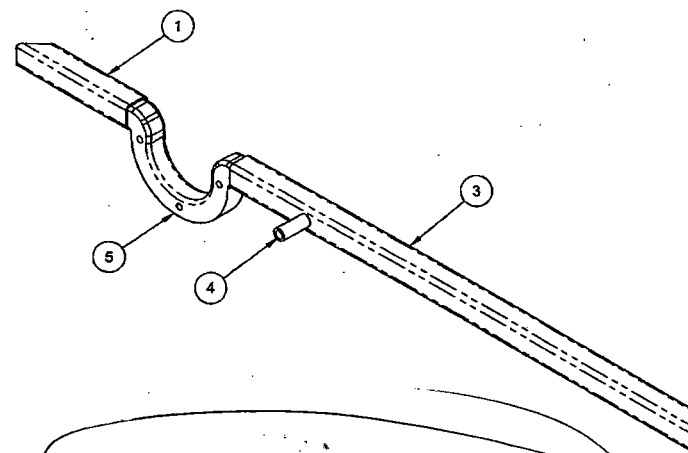
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
2011-01-18

#81431

B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	R	DRAWING NO.	REV. B
MFG. APPR.	[Signature]	D4034	SHEET 1 OF 4
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.12.20	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

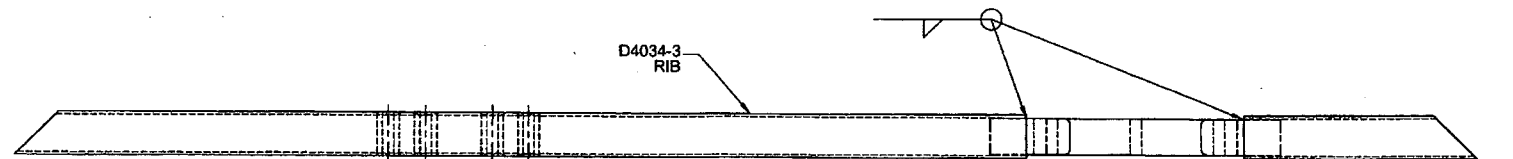
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

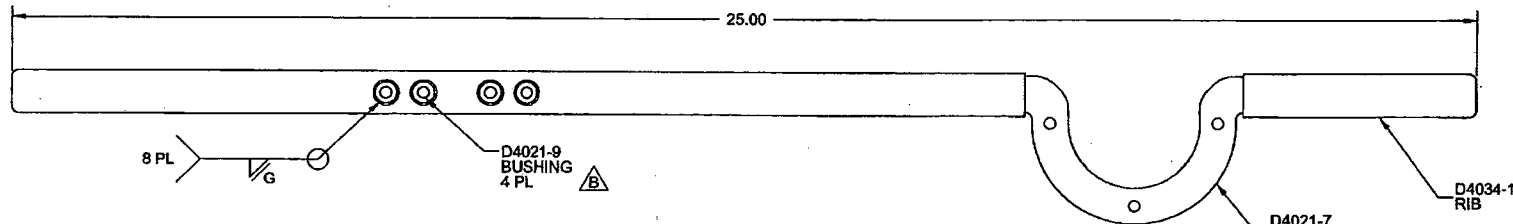
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NOTE: Date & initial all entries



D4034-3
RIB



D4034-041 AFT UPPER RIB ASSY

D4021-7
HOOP

D4034-1
RIB

8 PL

D4021-9
BUSHING
4 PL

25.00

#87431

RELEASED
2011-01-30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	B	DRAWING NO.	REV. B
MFG. APPR.	AD	D4034	SHEET 2 OF 4
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DE APPR.	AD	UPPER RIB ASSY, BASKET BASE	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

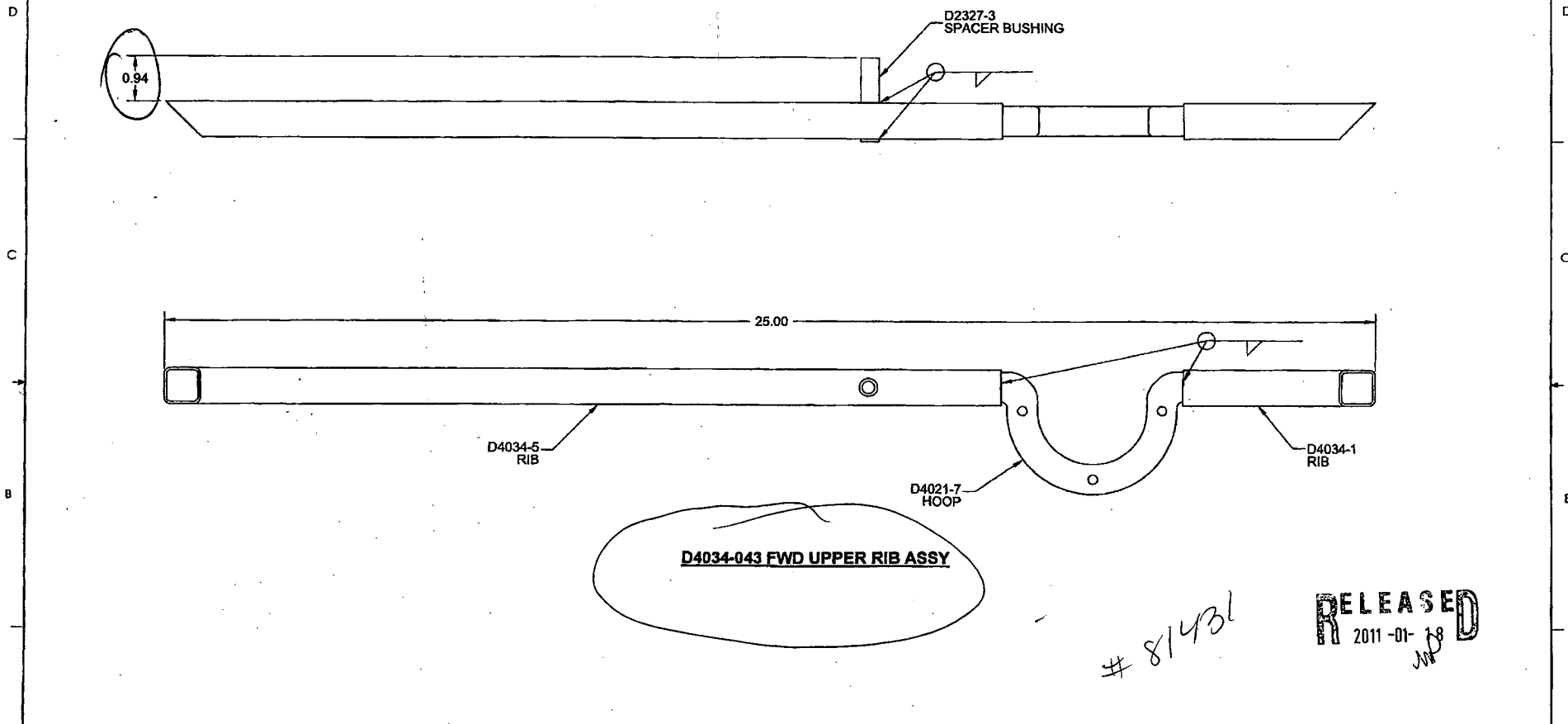
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.58 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO. D4034	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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2011-01-18

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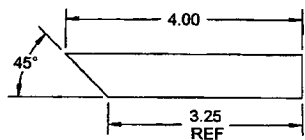
W/O:		WORK ORDER CHANGES					
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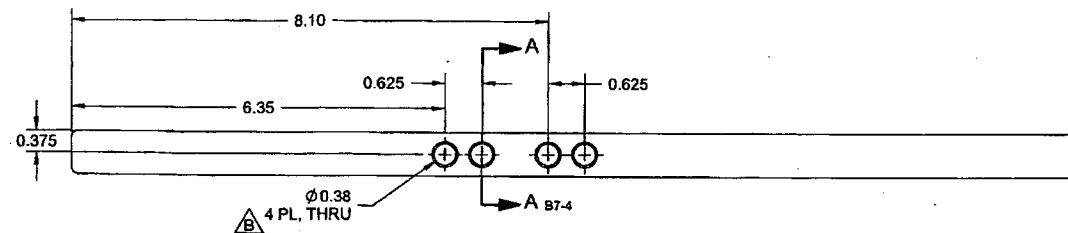


D4034-1 RIB

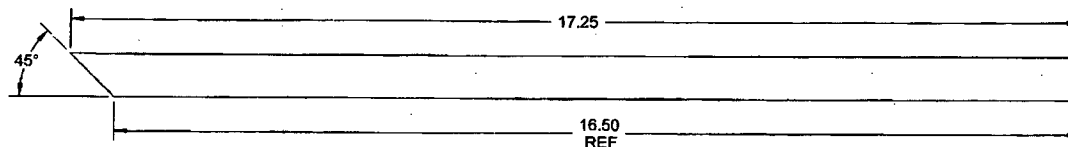
BREAK EDGE
0.030 X 45°
TYP



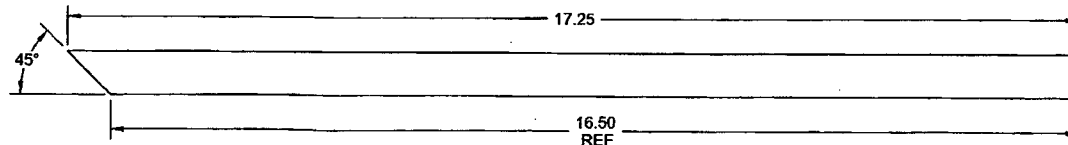
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4034	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	UPPER RIB ASSY, BASKET BASE	NTS
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RELEASED
2011-01-10

#87431

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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